



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

②

D119-796-241TRN
Job Sheet 203914



Part No: D119-796-241TRN

Job Qty: 1 pcs

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/13/19

Type: Stock

Description:

Note: DWG RD119-796 REV.K IPP REV A RQ 14/05/27 VERIFIED BY DD IPP REV:B 16.05.04 AS PER DWG REV.I DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
100	Mori Seiki TL-40 - 1	1 pcs	12/13/19	12/13/19	1.00 4.25	Mori Seiki TL-40 - 1		DAS 662019/12/05 9-89
110	QC 2	1 pcs	12/13/19	12/13/19	0.00 0.00	QC 2 - 1		
						QC 2 - 12		
						QC 2 - 14		
						QC 2 - 17		
						QC 2 - 19		
						QC 2 - 2		
						QC 2 - 20		
						QC 2 - 22		
						QC 2 - 23		
						QC 2 - 25		
						QC 2 - 32		
						QC 2 - 33		
						QC 2 - 35		
						QC 2 - 39		
						QC 2 - 4		
						QC 2 - 40		
						QC 2 - 44		
						QC 2 - 45		
						QC 2 - 48		
						QC 2 - 49		
						QC 2 - 50		
						QC 2 - 51		
						QC 2 - 52		
						QC 2 - 57		
						QC 2 - 62		
						QC 2 - 63		
						QC 2 - 8		DAS 662019/12/05 9-89
						QC 2 - 66		
						QC 2 - 64		

Plex 11/28/19 11:28 AM Dart.lajeunesse.marie

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Mori Seiki TL-40 - 1 - B4B	1	12/13/19	1.00 2.50	Mori Seiki TL-40 - 1 - B4B	DAS 66 2019/12/09 9-89
	pcs					
130	QC 2	1	12/13/19	0.00 0.00	QC 2 - 1	
	pcs				QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	DAS 66 2019/12/09 9-89
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	1	12/13/19	0.00 0.00	QC 8 - 12	
	pcs				QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	

						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	TW 19-12-30
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
145	Crosstubes - 2 - B4B	1 pcs	12/13/19	0.00	0.45	Crosstubes - 1 - B4B	
						Crosstubes - 2 - B4B	BB 12/30/19
						Crosstubes - 3 - B4B	
						Crosstubes - 4 - B4B	
150	Handfinish - 1-1 Chemical-B4B	1 pcs	12/13/19	0.00	0.40	Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	A JAN 07 2020
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
160	QC 7	1 pcs	12/13/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	

				QC 7 - 37	
				QC 7 - 41	DAS
				QC 7 - 47	47
				QC 7 - 48	9-89 19-12-23
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	DAS
				QC 7 - 81	76
				QC 7 - 76	9-89
				QC 7 - 79	
170	Packaging 3-1 - Stock - B4B	1	12/13/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
180	QC 21 - FG	1	12/13/19	0.00 0.00	QC 21 - FG - 21
	pcs				QC 21 - FG - 70
					QC 21 - FG - 53

Part Op 100 - 1-Fill tube with sand & install plugs on both ends as per Folio FB298 2-Turn first side as per Folio FB298

Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - 1-Turn second side as per Folio FB298
130 - (QC2- Inspect parts off machine FAI/FAIB)
140 - (QC8- Inspect parts - second check)
145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
150 - 1- Handfinish X-TUBE INSIDE AND OUT. ALODINE AND ACID ETCH X-TUBE AS PER DWG . USE RED SCOTCH BRITE PAD.
160 - (QC7-Inspect Chemical Conversion Coat)
170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG014
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6023-106	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	SOL-3837

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6023-106	1	2	0

Part Specifications

Specifications could not be found.



Container No: S237393



Part: D119 - 796 - 241TRN

Job No: 203914

Serial No/Batch: S237393

Revision: K

Inspector:

Exp Date:

Instructions:

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaero.com

Plex 11/28/19 11:28 AM Dart.lajeunesse.marie

Date: 12/05/19

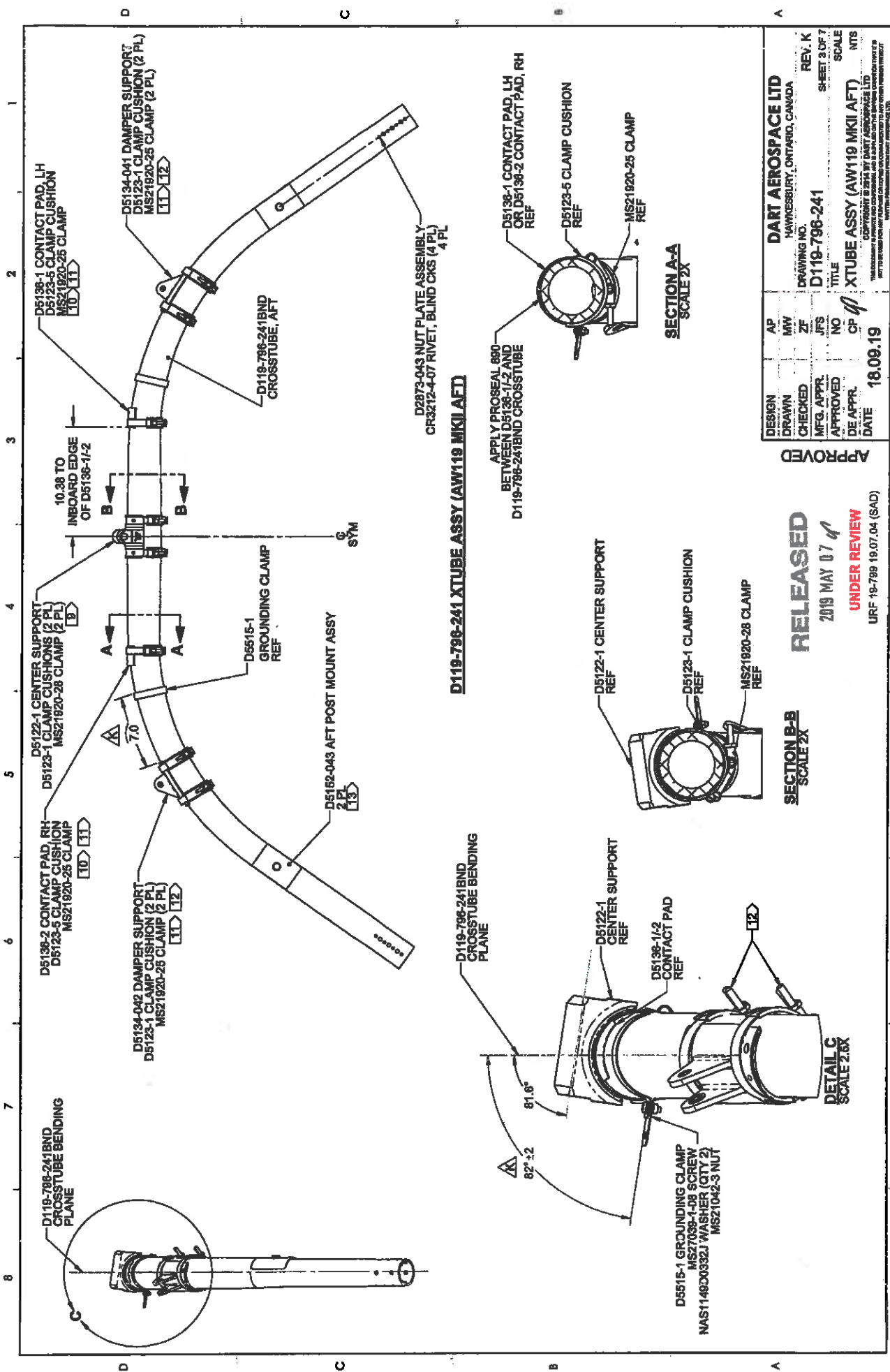
2

DART AEROSPACE LTD	Work Order: 203914
Description: Crosstube Assembly (AW119 MKII Aft)	Part Number: D119-796-241TRN
Inspection Dwg: D119-796-241 Rev: K	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	5.88	+/-0.030	5.876	✓		
	2.516	+0.005/-0.000	2.520	✓		
	2.626	+0.005/-0.000	2.631	✓		
	2.627	+0.005/-0.000	2.632	✓		
	2.798	+0.005/-0.000	2.803	✓		
	2.799	+0.005/-0.000	2.804	✓		
	2.989	+0.005/-0.000	2.994	✓		
	3.191	+0.005/-0.000	3.195	✓		
	3.200	+0.005/-0.000	3.204	✓		
SIDE B	5.88	+/-0.030	5.88	✓		
	2.516	+0.005/-0.000	2.521	✓		
	2.626	+0.005/-0.000	2.631	✓		
	2.627	+0.005/-0.000	2.632	✓		
	2.798	+0.005/-0.000	2.803	✓		
	2.799	+0.005/-0.000	2.804	✓		
	2.989	+0.005/-0.000	3.993	✓		
	3.191	+0.005/-0.000	3.196	✓		
	3.200	+0.005/-0.000	3.205	✓		
	105.71	+/-0.020	105.72	✓		

RECEIVED
JUL 19 19 07 04 (SAD)



DESIGN	AP	MW	ZF	JFS	NO	CP	DATE	18.09.19
DRAWN								
CHECKED								
MFG. APPR.								
APPROVED								
DE APPR.								

APPROVED

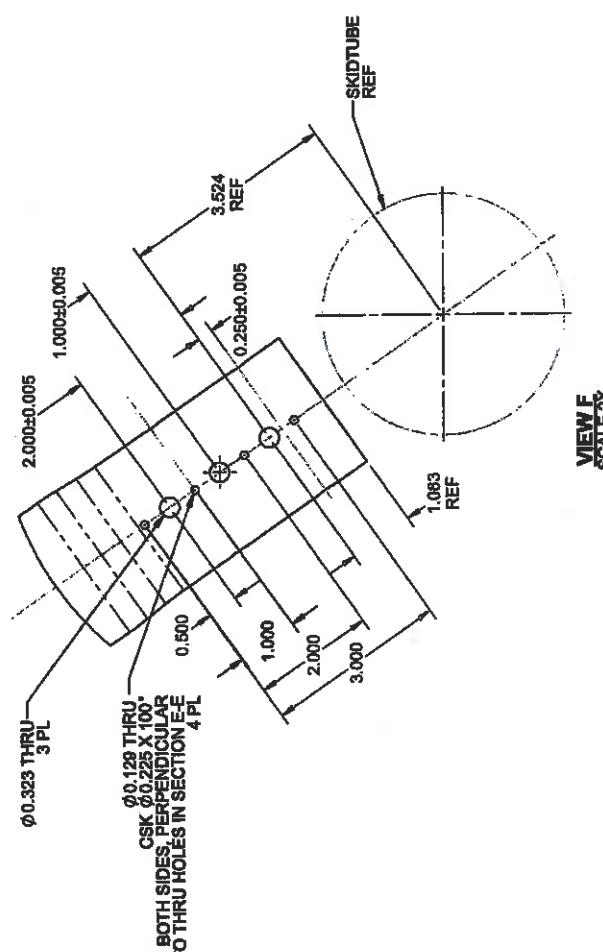
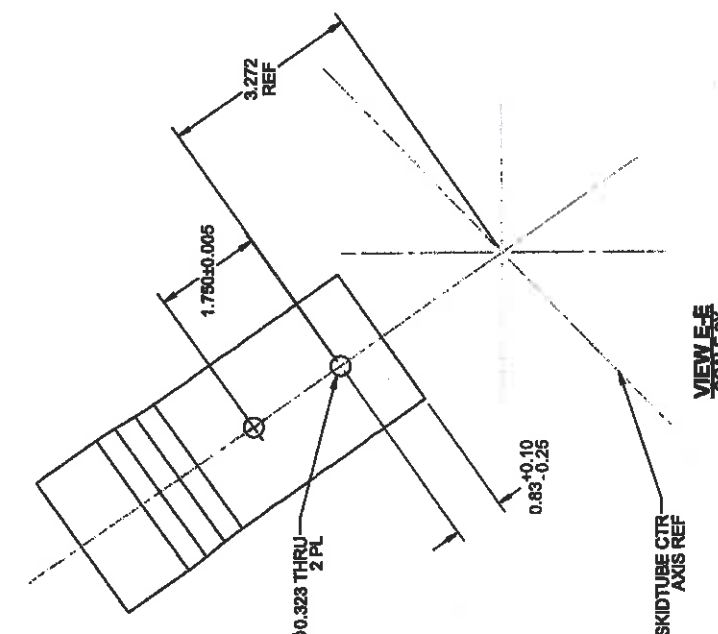
RELEASED
2019 MAY 07
UNDER REVIEW
URF 19-789 19.07.04 (SAD)

SECTION B-B
SCALE 2X

DETAIL C
SCALE 2X

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D119-796-241
TITLE XTUBE ASSY (AW119 MKII AFT)
SHEET 3 OF 7
SCALE NTS
COMPONENT IS 2014 BY DART AEROSPACE LTD
"MEASUREMENTS AND DIMENSIONS ARE IN INCHES AND DECIMALS THEREOF UNLESS OTHERWISE SPECIFIED"
PARTS LISTED FOR THIS DRAWING ARE SUBJECT TO CHANGE WITHOUT NOTICE

1 2 3 4 5 6 7 8



UNDER REVIEW
URF 19-799 19.07.04 (SAD)

RELEASED
2019 MAY 07

DESIGN	AP	MM	REV. K
DRAWN	CHECKED	ZF	DRAWING NO.
MFG. APPR.	JFS	NO	D119-798-241
APPROVED	CP	CP	TITLE
DATE	18.09.19		XTUBE ASSY (AW119 MKII AFT)

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
SHEET 6 OF 7
SCALE
NTS
COPYRIGHT © 2014 BY DART AEROSPACE LTD
THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE
NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION IN WRITING

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS								
		Rework Scrap Use-as-is			Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality		
Date :	Sequence #:	QTY Affected :		MRB (QS1042)									
Description Work Order Deviation				Disposition									
												Completed By	
												Lead hand / Supervisor	
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY									
				Pressure/Forced Bending Crushing Cracks Crimp/kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:				Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	